# ABSTRACT OF THE DISCLOSURE

In a threading control system for performing a threading

5   operation by moving, in synchronization with rotation of the

main-spindle, either a cutter or a workpiece in the feeding spindle

direction so that the ridge is not damaged nor the dimensional

accuracy of the thread is lowered even if the main-spindle speed is

variable, a threading computing section 3 and a main-spindle angle

10   computing section 4 are provided to alter the threading start timing

based on the servo-spindle acceleration time-constant of the

feeding spindle.